

# FLUX - CORED ARC WELDING



Flux-cored arc welding (FCAW or FCA) is a semi-automatic or automatic arc welding process. FCAW requires a continuously-fed consumable tubular electrode containing a flux and a constant-voltage or, less commonly, a constant-current welding power supply. An externally supplied shielding gas is sometimes used, but often the flux itself is relied upon to generate the necessary protection from the atmosphere. The process is widely used in construction because of its high welding speed and portability.

## RASI® E 71 - T 1 (SFA 5.20 AWS: E 71 T-1)

RASI E 71 T-1 Mild steel flux cored wire with rutile slag base, all position welding, stable arc and good slag detectability with Multi-pass welding.

### CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	S&P
PERCENTAGE	0.18	1.75	0.9	0.03

### ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm <sup>2</sup> )	>480	Elongation %	>22
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## RASI® E 71 - T 5 (SFA 5.20 AWS: E 71 T-5)

RASI E 71 - T5 Low hydrogen flux cored wire with Basic slag base, all position welding, stable arc and good slag detachability

### CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	S&P
PERCENTAGE	0.18	1.75	0.9	0.03

### ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm <sup>2</sup> )	>480	Elongation %	>22
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## RASI® E 90T5-G (SFA 5.29 AWS: E 90T5-G)

RASI E 90T5-G Low hydrogen low alloy high-tensile lime fluoride base slag with uniform weld bead. The weld metal is radiographically sound.

### CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	Mo	S&P
E%	0.15	2.25	0.8	0.55	0.03

### ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm <sup>2</sup> )	>620	Elongation %	>17
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## RASI® E 308L-TI (SFA 5.22 AWS: E 308L-T1-1)

RASI E 308L-T1 Stainless Steel Flux Cored wire with rutile slag base, for all position welding, stability arc and good slag detachability.

### CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	Cr	Ni
PERCENTAGE	0.04	0.5-2.5	1.0 Max	18-21	09-11

### ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm <sup>2</sup> )	>520	Elongation %	>35
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## RASI® E 309L-TI (SFA 5.22 AWS: E 309L-T1-1)

RASI E 309L-T1 Stainless Steel Flux Cored wire with rutile slag base, for all position welding, stable arc and good slag detachability.

### CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	Cr	Ni
PERCENTAGE	0.04	0.5-2.5	1.0 Max	22-25	12- 14

### ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm <sup>2</sup> )	>520	Elongation %	>35
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NOTE: ALL SINGLE VALUES ABOVE ARE MAXIMUM

PACKING	LAYER WINDING 15 Kgs (Net)
PRECAUTION	Use short ARC during welding, Store the wire in Dry Condition